

Date: Thursday, 19/06/2008 2:33:45 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SWING ARM
Job Number	: 39968		
Estimate Number	: 11303		
P.O. Number	:	Part Number	: D34479
This Issue	: 19/06/2008 S.O. No. :	Drawing Number	: D3447
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 35550	Material	:
Written By	:	Due Date	: 05/07/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JUL 08.6.19</u>		
Comment	: Est A 05.08.26 New issue KJ/JLM		

Additional Product.

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M7075T6B1500X1500	7075 T6 BAR
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Comment: Qty.: 0.7350 f(s)/Unit Total : 14.7000 f(s)
 7075 T6 BAR
 Material: 7075-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M7075T6B1.500x01.500)
 Identify for D3447-9
 Batch: M18147

J.L 08/06/25

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 1.500" x 1.500" x 8.400" long

J.L 08/06/25

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA544 and Dwg B67-43001
 Identify as D3447-9Dwg Rev A Folio Rev AA
 Deburr

J.L 08/06/26 (20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/06/26

(20)

5.0	QC8	SECOND CHECK
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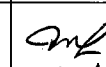
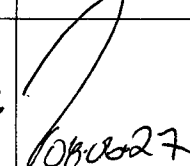
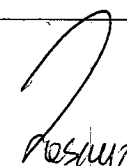
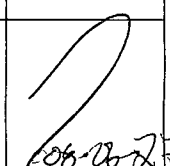
Comment: SECOND CHECK

J.L 08/06/27 (20)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3447-9 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: D Date: 08/07/16
D412-695 QA: N/C Closed: D Date: 08/07/17

NCR: 39968		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/26	3	1 part scrap, the part pop out of the vise.		scrap and destroy Qty: 1 Batch: 18147 Replace for Qty 20	 08/06/26	 08/06/27	 08/06/27	 08/06/27

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SWING ARM

Job Number: 39968

Part Number: D34479

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(20X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m.f. 08/07/02

7.0

POWDER COATING

POWDER COATING



m102316

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

Mask inside holes as per Dwg D3447 prior to painting

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320
11:00

BR / Q17 08/07/10

(20X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(20X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/07/10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Part K.

mf 08-07-14

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

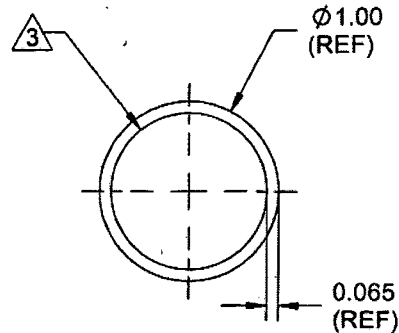
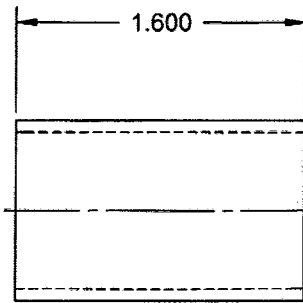
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

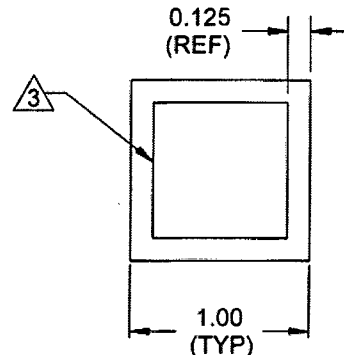
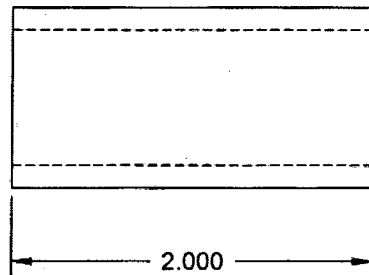
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3447	REV. A SHEET 1 OF 4
DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:1
A	05.07.19	NEW ISSUE	

RELEASED
[Signature]
05/08/18

**D3447-1 ROUND SPACER**

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)

**D3447-3 SQUARE SPACER**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115/ 4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.000W.125)

NOTES:

- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK INSIDE OF TUBING BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 39968

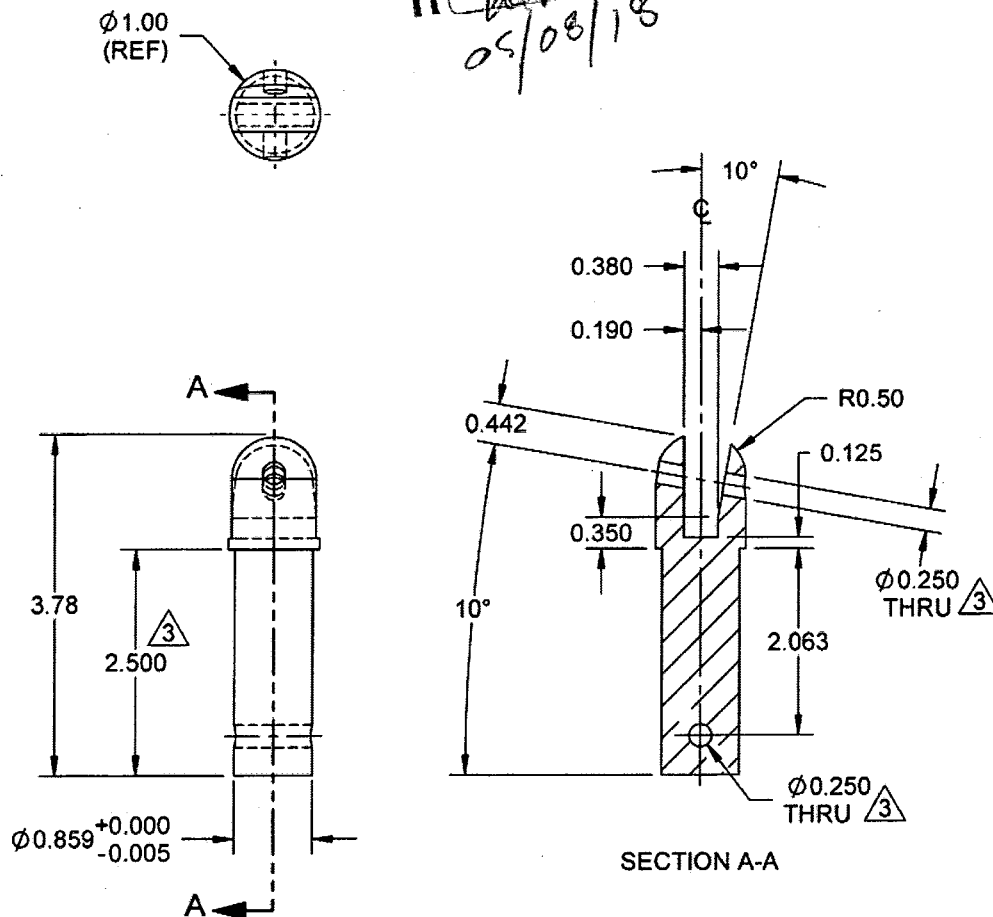
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

RELEASED
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05/08/18

**D3447-5 CLEVIS****SUPERSEDES PREMIER P/N B67-43001-99****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R1.000)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

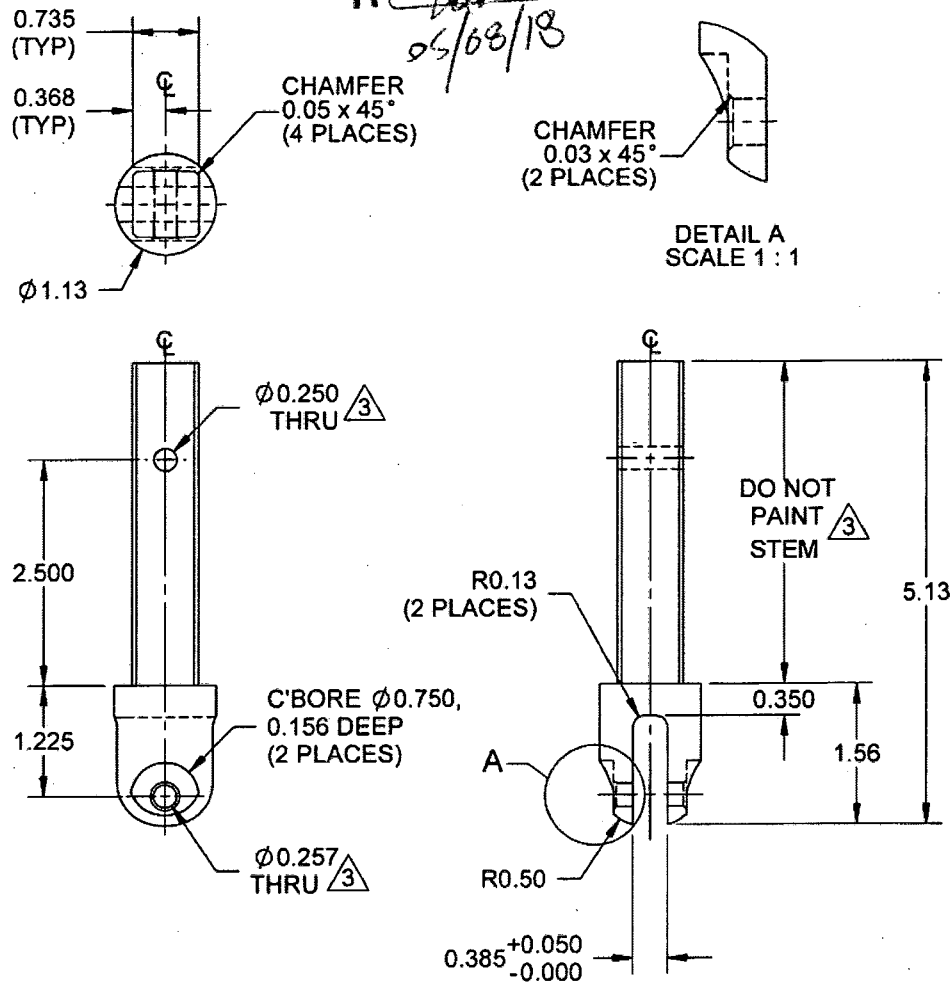
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

RELEASED
05/08/18

D3447-7 CLEVIS
SUPERCEDES PREMIER P/N B67-43001-145/-345

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R1.125)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK AND COVER INSIDE HOLES AS SHOWN PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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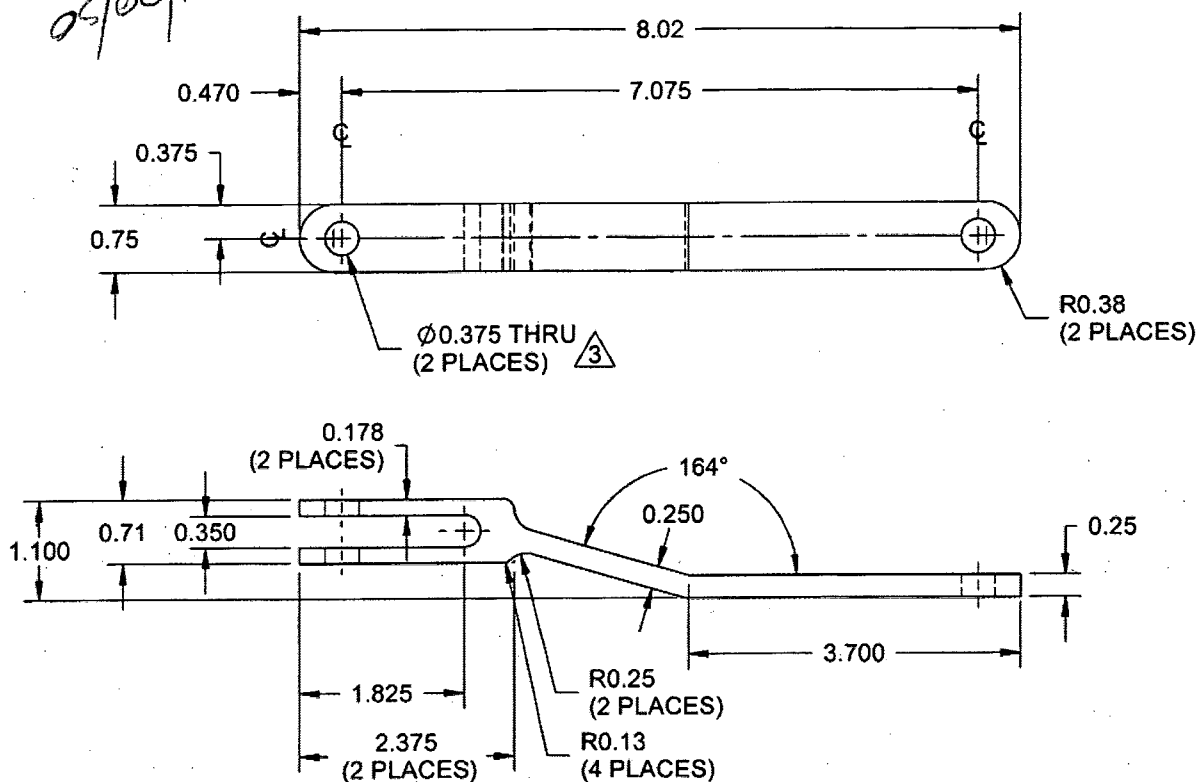
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DATE 05.07.19		TITLE BLADE FOLD KIT PARTS	SCALE 1:2

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[Signature]
05/08/18



D3447-9 SWING ARM
SUPERSEDES PREMIER P/N B67-43001-263

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T652) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) COVER INSIDE HOLES PRIOR PAINTING
- 4) FINISH: POWDER COAT PAINT GREEN SANDEX (4.3.5.8) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 39968
Description: SWING ARM		Part Number: D3447-9
Inspection Dwg: D3447 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.02	$\pm .036$	8.020	—			
7.075	$\pm .005$	7.080	—			
R.38	$\pm .030$	R.380	—			
$\emptyset .375$	$\begin{matrix} + .006 \\ - .001 \end{matrix}$	$\emptyset .377$	—			
.75	$\pm .036$.750	—			
.375	$\pm .005$.370	—			
.470	$\pm .005$.468	—			
1.100	$\pm .010$	1.109	—			
.71	$\pm .036$.708	—			
.178	$\pm .010$.179	—			
1.825	$\pm .010$	1.825	—			
2.375	$\pm .010$	2.377	—			
R.25	$\pm .036$	R.250	—			
R.12	$\pm .036$	R.125	—			
3.700	$\pm .010$	3.702	—			
.25	$\pm .036$.253	—			

Measured by: <i>MR</i>
Date: 08/06/26

Audited by: <i>DTA</i>
Date: 08/06/26

Prototype Approval: <i>WCA</i>
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	